

Work Order ID 50562

July 15, 2009 1:38:50 PM

TODAY PLEASE

Page 1

Item ID: D3506-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Doubler

Start Date: 7/16/09 Start Qty: 20.00

Cust Item ID:

Required Date: 7/17/09 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3506

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3506 ! Dwg Rev: A ! Prog Rev: A ! 12-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA640 and Dwg D3506

m 09 07 15 (20)

m. h 09/07/16 (20x)

8/09/07/16 (20)

Work Order ID 50562

July 15, 2009 1:38:50 PM



Page 2

Item ID: D3506-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 7/16/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/17/09 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

8/8 09/07/16

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2L 09/07/16

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

C'sink as per Dwg D3506(On Flat side)

EP 09/07/16 (20)

Work Order ID 50562

July 15, 2009 1:38:50 PM

Page 3

Item ID: D3506-1

Accept

Revision ID: A

Item Name: Doubler

Start Date: 7/16/09

Start Qty: 20.00

Required Date: 7/17/09

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



=>

808/07/16

count
(20)

6

UMP 09/07/16

(20)

BR 09-07-16

(20)

Work Order ID 50562

July 15, 2009 1:38:50 PM



Item ID: D3506-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 7/16/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/17/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Brcly

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21

W 09.07.20

Picklist Print

July 15, 2009 1:38:49 PM

Page 1

Work Order ID: 50562

Parent Item: D3506-1RevA

Parent Item Name: Doubler

Comments:

Start Date: 7/16/09

Required Date: 7/17/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.100

Purchased

No

110

sf

64.5000

0.1642



6061-T6 .100 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64.5

102201

64.5

mm.mmm 09 07 15

DART AEROSPACE LTD		Work Order:	50562
Description: DOUBLER		Part Number:	D3506-1
Inspection Dwg: D3506 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

11

Prototype

[illegible]

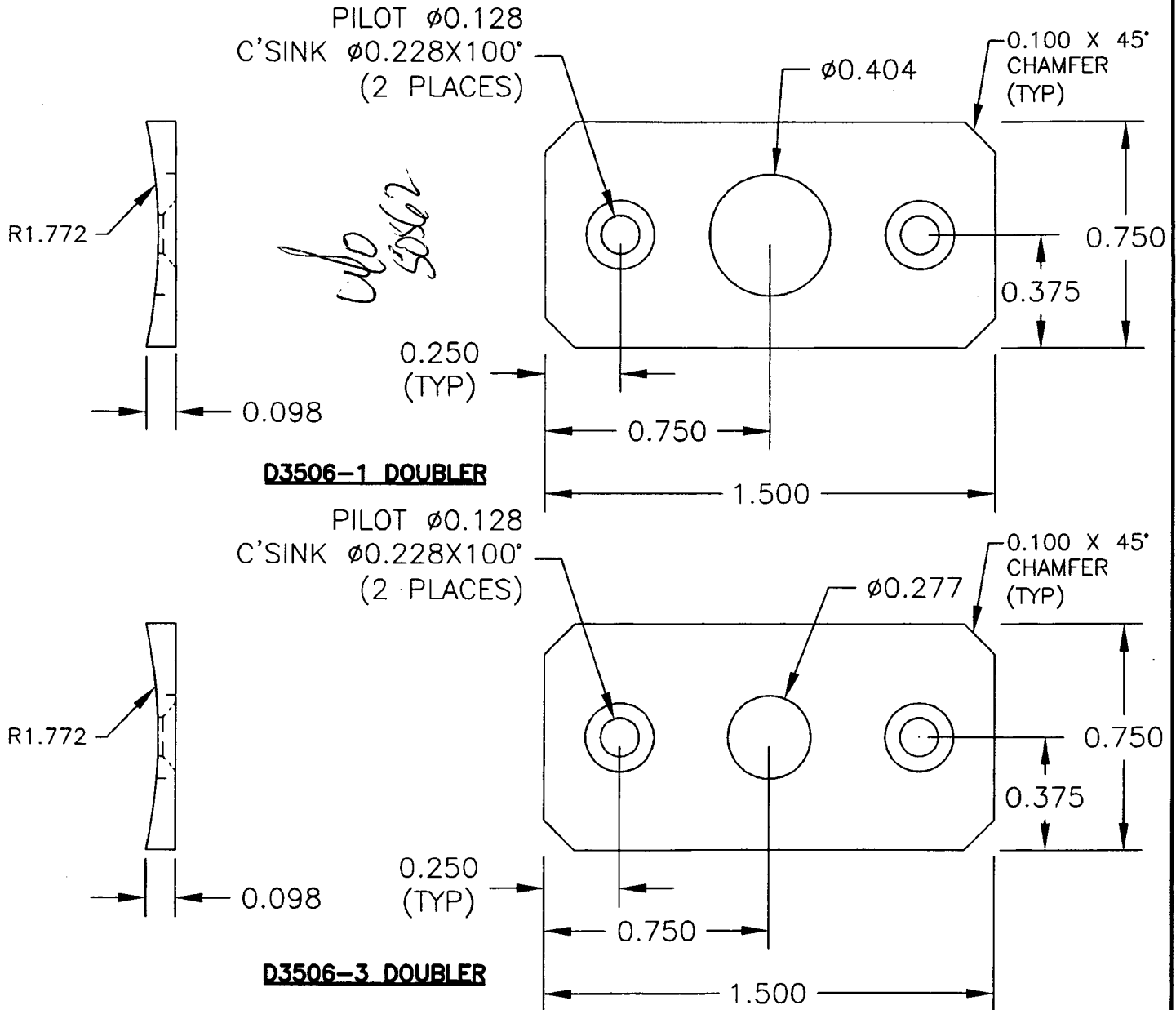
11/07/18

Measured by:	<i>M. M.</i>	Audited by:	<i>JK</i>	Prototype Approval:	
Date:	<i>09/07/15</i>	Date:	<i>09/07/16</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	...	New Issue	KJ/JLM	

DART

DESIGN HH	DRAWN BY HH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED HH	APPROVED HH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.03 PM
per ECU #861**Copyright © 2006 by DART AEROSPACE USA, INC.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.